

Date: Monday, 4/23/2007 3:41:54 PM
 User: Kim Johnston

Process Sheet

②

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 32022
 Estimate Number : 10833
 P.O. Number : N/A
 This Issue : 4/23/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : MACHINED PARTS
 Previous Run : 31490
 Drawing Name : 206/OH-58 SADDLE, INBOARD, LEFT SIDE
 Part Number : D29331
 Drawing Number : D2933 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 5/15/2007 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : 07.04.23
 Comment : Est: B 00.06.26 New-DWG rev (mpp 2069) EC
 Est Rev: C As per Rev C 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101001 7075-T7351 2X6X6.25



Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Issue material from stock: 7075-T7351 QQ-A-250/12

Cut Size 2.0 x 6.25 X 6.00

Grain Along Long 6.00 Length

Batch No: B25345 x 7 pcsB31386 x 1 pcsJ.F. 07/07/30

⑧

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet

5-Deburr

J.F. 07/07/30

⑧

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

J.F. 07/07/30

⑧

4.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

J.F. 07/07/30

⑧

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/08/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 3:41:54 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 32022

Part Number: D29331

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



JA/07-07-31

Comment: SECOND CHECK

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

07-08-01

(8)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BR

07-08-02

(8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-J

07/08/02

(8X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/08/02

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/03

Job Completion



JA/07-08-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32022
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.121"	.121"	.122"	.121"		
B	0.100	0.140		.120"	.121"	.121"	.119"		
C	0.100	0.140		.117"	.117"	.115"	.115"		
D	0.210	0.230		.219"	.220"	.220"	.221"		
E	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
F	1.245	1.255		1.250"	1.250"	1.250"	1.250"		
G	2.495	2.505		2.500"	2.500"	2.500"	2.500"		
H	0.510	0.515		.512"	.512"	.512"	.512"		
I	1.572	1.582		1.578"	1.578"	1.578"	1.578"		
J	2.495	2.505		2.501"	2.501"	2.501"	2.501"		
K	0.257	0.262		Ø .258"	Ø .258"	Ø .258"	Ø .258"		
L	0.312	0.317		Ø .314"	Ø .314"	Ø .314"	Ø .314"		
M	0.235	0.240		.239"	.239"	.239"	.239"		
N	0.100	0.140		.118"	.119"	.119"	.118"		
O	0.540	0.560		.551"	.550"	.550"	.551"		
P	0.490	0.510		.503"	.502"	.502"	.503"		
Q	3.715	3.725		3.721"	3.721"	3.721"	3.721"		
R	2.470	2.510		2.496"	2.496"	2.496"	2.496"		
S	0.240	0.270		.248"	.249"	.250"	.251"		
T	0.100	0.180		.130"	.130"	.130"	.130"		
U	1.625	1.635		1.630"	1.630"	1.630"	1.630"		
V	1.362	1.372		1.369"	1.369"	1.369"	1.369"		
W	0.316	0.321		Ø .319"	Ø .319"	Ø .319"	Ø .319"		
X	1.125	1.145		1.134"	1.134"	1.134"	1.134"		
Y	1.565	1.585	DT8695 A/B	1.580	1.581	1.580	1.580		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	J.F.
Date:	07/07/30

Audited by:	[Signature]
Date:	07-07-31

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]

DART AEROSPACE LTD	Work Order: 32022
Description: 206 Saddle, Inboard, Left side	Part Number: D2933-1
Inspection Dwg: D2933 Rev. C	Page 1 of 1

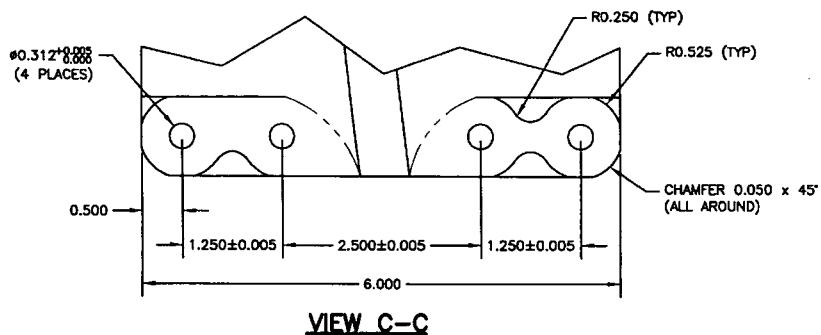
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.121	0.122	0.121	0.121		
B	0.100	0.140		0.121	0.121	0.120	0.121		
C	0.100	0.140		0.123	0.126	0.126	0.125		
D	0.210	0.230		0.218	0.219	0.219	0.219		
E	1.245	1.255		1.249	1.250	1.250	1.250		
F	1.245	1.255		1.249	1.250	1.250	1.249		
G	2.495	2.505		2.499	2.500	2.500	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.580	1.578	1.578	1.577		
J	2.495	2.505		2.498	2.498	2.498	2.498		
K	0.257	0.262		0.258	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.118	0.118	0.118	0.118		
O	0.540	0.560		0.551	0.550	0.550	0.550		
P	0.490	0.510		0.502	0.503	0.503	0.503		
Q	3.715	3.725		3.718	3.718	3.718	3.718		
R	2.470	2.510		2.492	2.492	2.495	2.494		
S	0.240	0.270		0.250	0.250	0.249	0.249		
T	0.100	0.180		0.136	0.136	0.135	0.138		
U	1.625	1.635		1.628	1.628	1.628	1.628		
V	1.362	1.372		1.366	1.367	1.367	1.367		
W	0.316	0.321		0.320	0.320	0.320	0.320		
X	1.125	1.145		1.133	1.134	1.133	1.135		
Y	1.565	1.585	DT8695 A/B	1.579	1.580	1.578	1.580		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: J.F.	07/10/13
Date: Jm	07/10/13

Audited by: [Signature]	07/07/13
Date:	

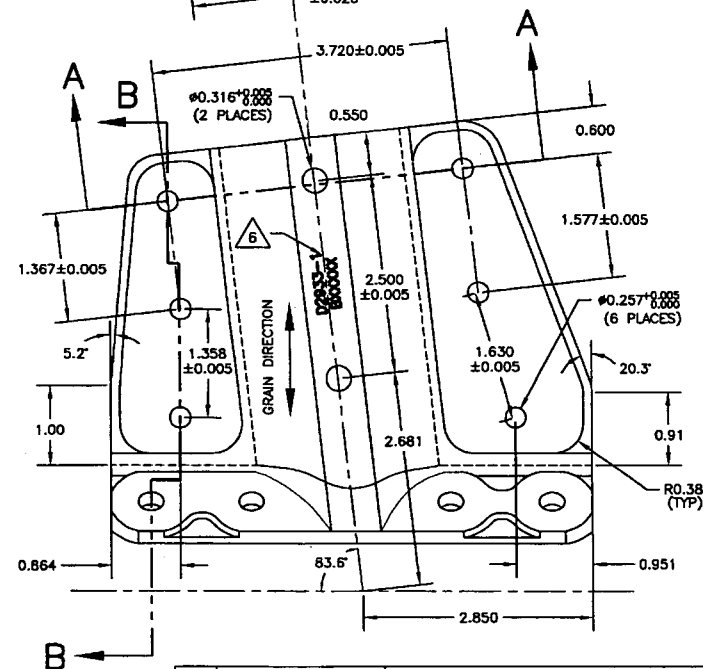
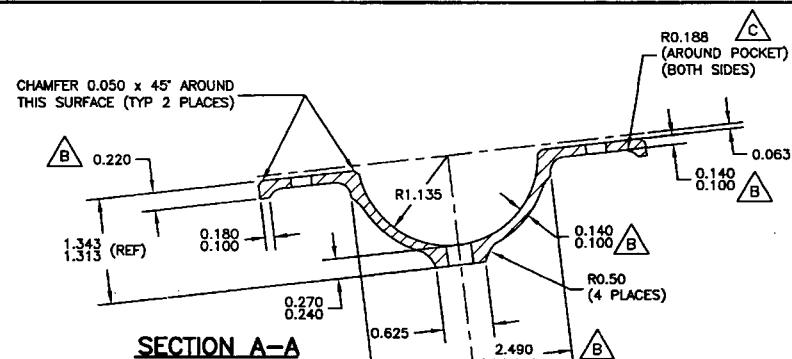
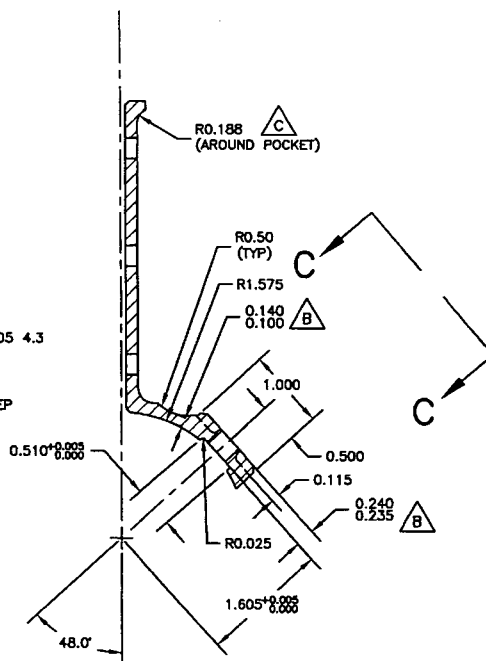
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	[Signature]



D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	4	DRAWN BY CB
CHECKED	PH	APPROVED
DATE	06.11.09	TITLE SADDLE INSIDE
DRAWING NO. D2933		REV. C SHEET 1 OF 1
DART AEROSPACE USA, INC. BELLEVUE, WA		SCALE 2:3

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07.02.12